

Work Order ID 95746***95746***

Page 1

January-18-13 10:22:11 AM

Item ID: D2013-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Mirror Bracket RH, 212

Start Date: 1/10/13 Start Qty: 4.00

**4*/
*4**

Required Date: 1/16/13 Req'd Qty: 4.00

9

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *MLZ*Date: *13-01-21* Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| 100 | | 0.00 | | | | | | | |
| *100* | NC BRAKE | | | | | | | | |
| Brake NC | Memo | 0.00 | | | | | | | |
| Brake NC | 1-Punch as per template D2013-T3 and Dwg D2013 2-Flatten ends of D2013-3 tube as per Dwg D2013 using DT8545 3-Bend (1) tube as per Dwg D2013 using Jig DT8201 Identify as D2013-3. 4-Deburr as required | | | | | | | | |
| 110 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *110* | Memo | 0.00 | | | | | | | |
| QC | | | | | | | | | |
| Quality Control | | | | | | | | | |

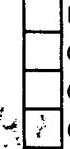
*(9) EZ 13-3-4**(9) 13-03-06 DAS 109*

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: Date:

QA Closed: Date:

| Work Order: _____ | | | DISPOSITION | | | AGAINST DEPARTMENT/PROCESS | | | | | |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------|----------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|--------------------|--------------|--|--|
| | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | | |
| Part No. _____ | | | | | | | | | | | |
| NCR No. _____ | | | | | | | | | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
|  <ul style="list-style-type: none"> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input checked="" type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | Landing Gear | | | General | | | | | | | |
| | <input type="checkbox"/> | Bend | <input type="checkbox"/> | Grain | <input type="checkbox"/> | Ovalized | <input type="checkbox"/> | Pressure/Forced | | | |
| | <input type="checkbox"/> | BOM/Route | <input type="checkbox"/> | Hardware | <input type="checkbox"/> | Over/Under tolerance | <input type="checkbox"/> | Temperature/Cure | | | |
| | <input type="checkbox"/> | Broken/Damaged | <input type="checkbox"/> | Inspection Incomplete | <input type="checkbox"/> | Part Incorrect | <input type="checkbox"/> | Weld | | | |
| | <input type="checkbox"/> | Burrs | <input type="checkbox"/> | Instructions Incomplete/Unclear | <input type="checkbox"/> | Part Lost/Missing | <input type="checkbox"/> | Wrong Stock Pulled | | | |
| | <input type="checkbox"/> | Contamination | <input type="checkbox"/> | Maintenance | <input type="checkbox"/> | Part Moved | <input type="checkbox"/> | | | | |
| | <input type="checkbox"/> | Countersink | <input type="checkbox"/> | Mislabeled | <input type="checkbox"/> | Positioned Wrong | <input type="checkbox"/> | | | | |
| | <input type="checkbox"/> | Cut Too Short | <input type="checkbox"/> | Misread | <input type="checkbox"/> | Power Loss/Surge | <input type="checkbox"/> | | | | |
| | <input type="checkbox"/> | Drill Holes | <input type="checkbox"/> | Offset | <input type="checkbox"/> | | <input type="checkbox"/> | | | | |
| | <input type="checkbox"/> | Drawing | <input type="checkbox"/> | Out of Calibration | <input type="checkbox"/> | | <input type="checkbox"/> | | | | |
| | <input type="checkbox"/> | Finish | <input type="checkbox"/> | Out of Sequence | <input type="checkbox"/> | | <input type="checkbox"/> | | | | |
| | <input type="checkbox"/> | Folio | <input type="checkbox"/> | Outside Dimensions | <input type="checkbox"/> | | <input type="checkbox"/> | | | | |
| | | | | | | | <input type="checkbox"/> | Other | | | |
| | | | | | | | <input type="checkbox"/> | | | | |
| | | | | | | | <input type="checkbox"/> | | | | |

Work Order ID 95746

January-18-13 10:22:11 AM

95746

Page 2

Item ID: D2013-4

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Mirror Bracket RH, 212

Stop

NS2

Start Date: 1/10/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/16/13 Req'd Qty: 4.00

4

Customer:

Reference:

| | | | | | | | |
|------------|---------------|-------|------------|-------|-----|-------|--------------|
| Approvals: | Process Plan: | Date: | Tooling: | Date: | Run | Start | *NR1* |
| | QC: | Date: | SPC (Y/N): | Date: | | Stop | *NR2* |

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|----------------------------------|------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|-------------------|
| 120 *120* Packaging | Identify as per dwg & Stock Location: <i>W/A 001</i> | 0.00 | | | | 9 | 0 | 13-3-14 | |
| | Memo | 0.00 | | | | | | | |
| 130 *130* QC | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | <i>13/3/18 JJ</i> |
| | Memo | 0.00 | | | | | | | |

13-03-14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE



DQA: _____ Date: _____

QA Closed: _____ Date: _____

| Work Order: _____ | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | | |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|-----------------------------------------------|-------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------|-----------------------------------------|--------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| | | Rework <input type="checkbox"/> | Scrap <input type="checkbox"/> | Skid-tube <input type="checkbox"/> | Machining <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | |
| | | Use-as-is <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | |
| | | Work Order Update <input type="checkbox"/> | | | | Rec/Store/Packaging <input type="checkbox"/> | Supplier <input type="checkbox"/> | Other <input type="checkbox"/> | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | | |
| Doc/Data | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | |
| Operator | | | | | | | | | | | |
| Material | | | | | | | | | | | |
| Setup | | | | | | | | | | | |
| Other | | | | | | | | | | | |
| Process | | | | | | | | | | | |
| Supplier | | | | | | | | | | | |
| Training | | | | | | | | | | | |
| Unapproved | | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio | | <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/> | |
| | | | | | | | | | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled | |
| | | | | | | | | | | <input type="checkbox"/> Other | |

Picklist Print

Page 1

January-18-13 10:22:11 AM

Work Order ID: 95746

Parent Item: D2013-4

Parent Item Name: Mirror Bracket RH, 212

Start Date: 1/10/13

Required Date: 1/16/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-01 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|----------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TR0.750W.049 304 RD Tube .750 x .049W | | Purchased | No | | | 100 | f | 418.9640 | 1.9473 | 8.1991579 | EL 13-3-4 | | |

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT017 | 418.9640325 | |
| 109314 | 18.666 | |
| 111619 | 6 | |
| 112187 | 8 | |
| 120441 | 0.008734 | |
| 121170 | 234.89 | |
| 121666 | 15.134 | |
| 122312 | 26.37 | |
| 122468 | 109.895299 | |

M 124768 X ~~14~~ 14'

~~122312~~

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

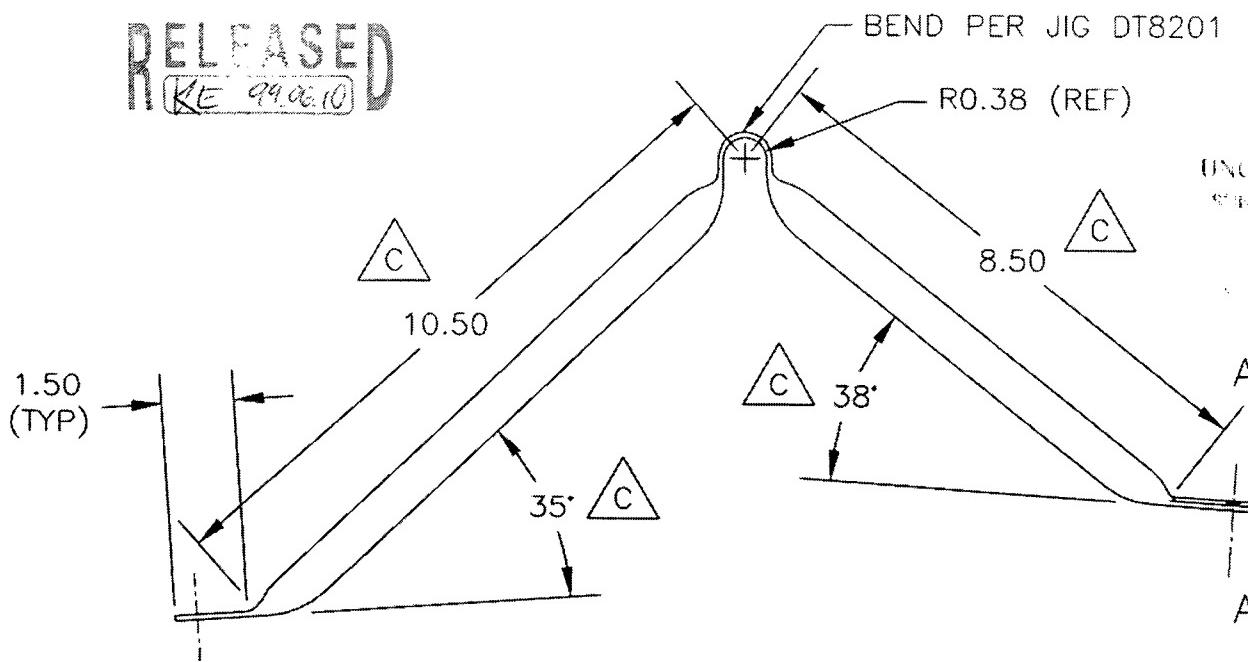
QA Closed: _____ Date: _____

| Work Order: _____ | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------|--------------|--------------|--|
| | | | Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> | Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> | Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> | Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> | | | |
| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector | |
| Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/> | | | | | | | | | | |
| FAULT CATEGORY | | | | | | | | | | |
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | | | | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions | | | | | | |
| | | | | <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | | | | | |

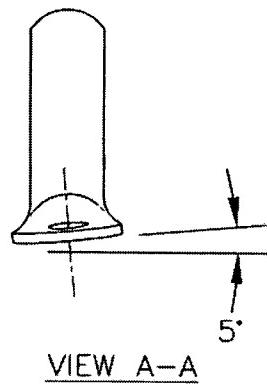
RELEASED
KE 09.06.10

DART

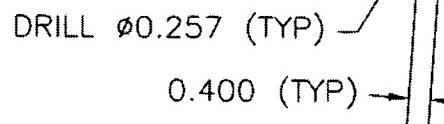
DA COPY
GENERIC



D2013-1 LH SHOWN
D2013-2 RH OPPOSITE
(FOR 205 MIRROR)



CUT LENGTH: 23.25 INCHES



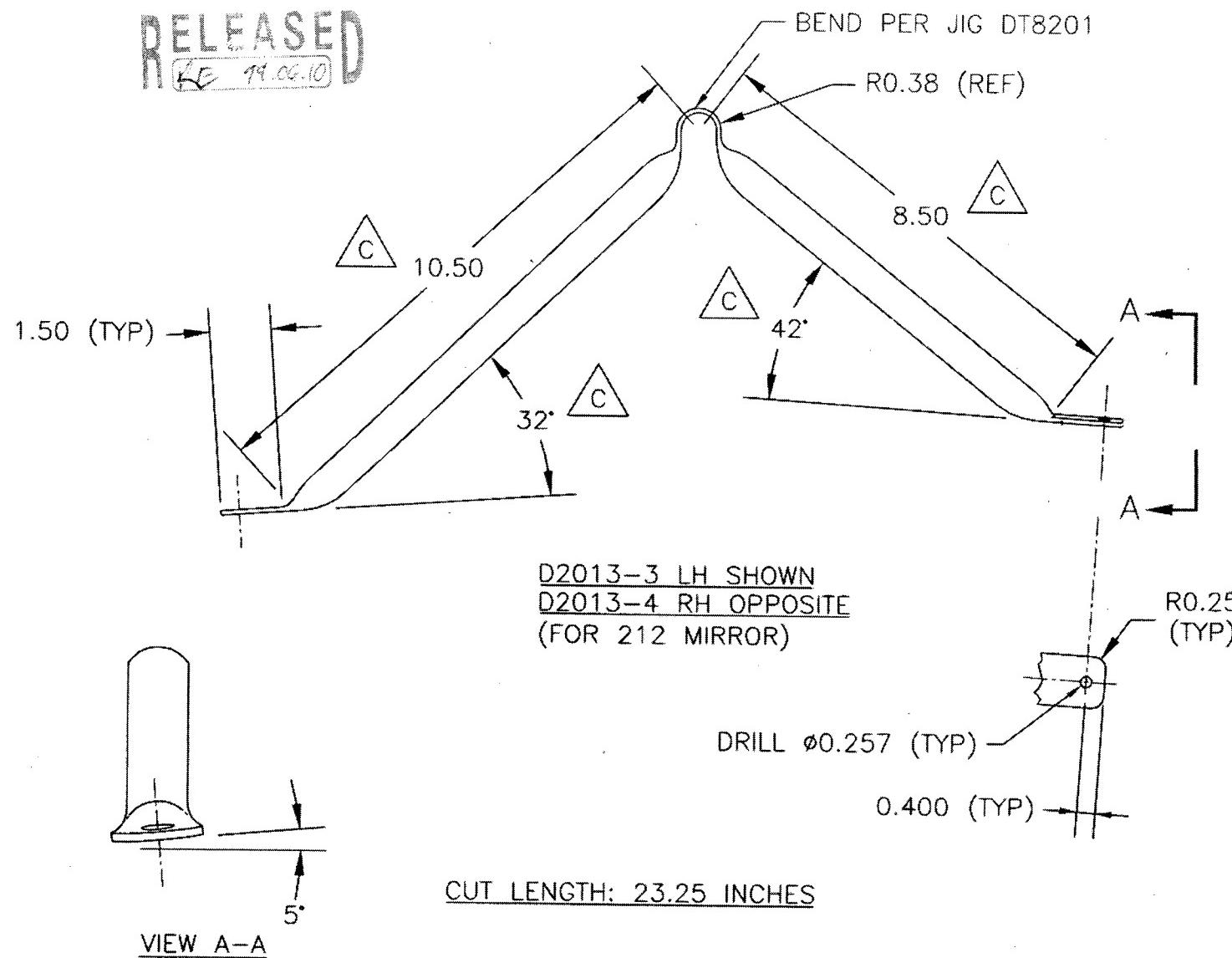
MATERIAL: AISI 304/316 SS SEAMLESS TUBE,
0.750 OD x 0.049 WALL

| DESIGN JB. | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | REV. C |
|------------------|-------------------------|---------------------------------------------------|--------------|
| CHECKED KE | APPROVED JS | DRAWING NO. D2013 | SHEET 1 OF 3 |
| DATE 99.06.07 | TITLE MIRROR BRACKET | SCALE NTS | |
| A | 90.10.22 | NEW ISSUE | |
| B | 94.06.15 | REDRAWN | |
| C | 99.06.07 | REDRAWN, CHANGE OF DIMENSIONS | |

95746

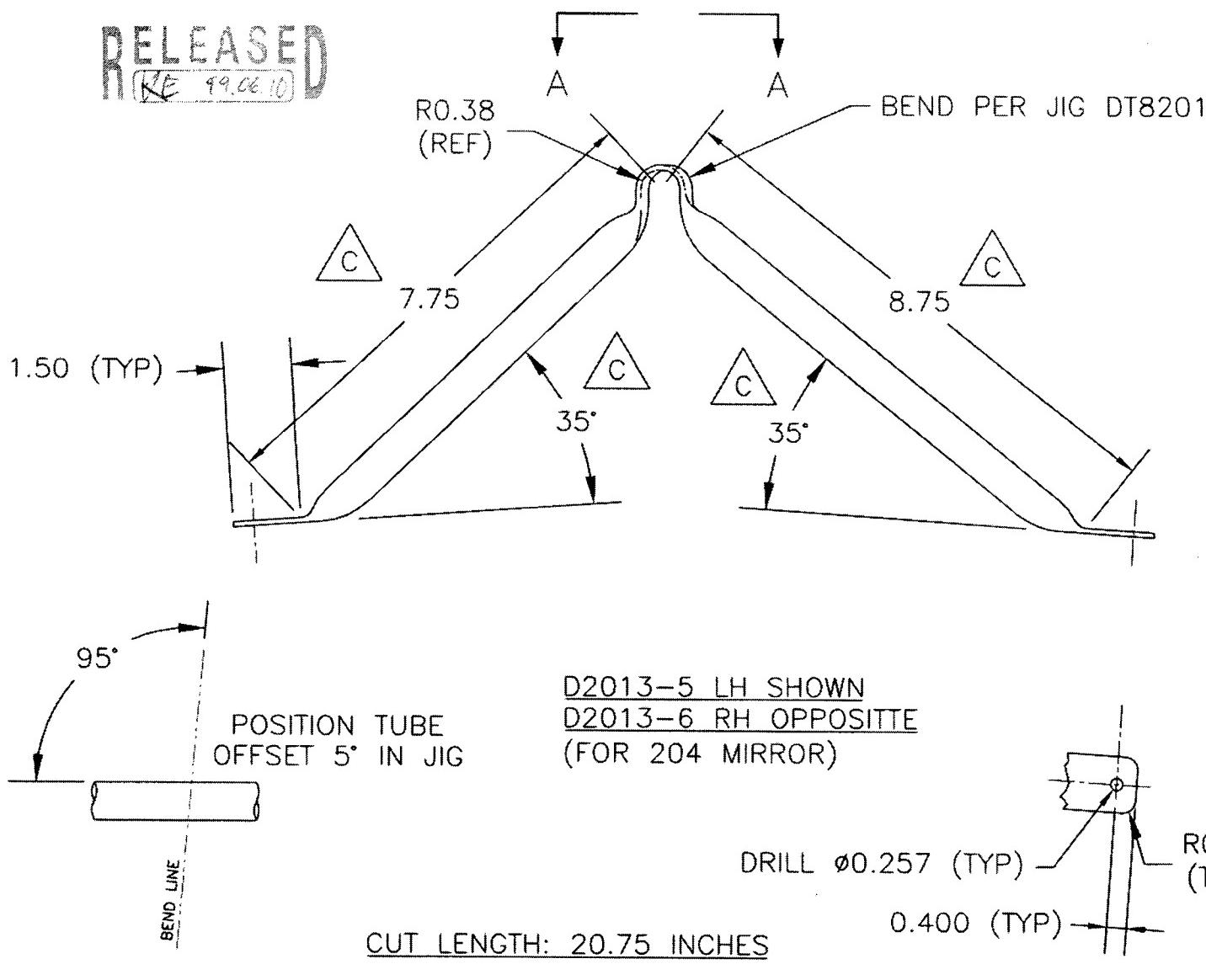
DARTA COPY
IS
MADE
FOR
REFERENCE
ONLY

| | | |
|----------------------------|--------------------------------|---------------------------------------------------|
| DESIGN NO. <u>JB</u> | DRAWN BY <u>RF</u> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <u>KE</u> | APPROVED <u>JF</u> | DRAWING NO. <u>D2013</u> |
| DATE <u>99.06.07</u> | TITLE <u>MIRROR BRACKET</u> | REV. C SHEET 2 OF 3 SCALE <u>NTS</u> |



95746

RELEASED
RE 99.06.10

**DART**COPY ISSUED
DA

| | | |
|------------------|-------------------------|---------------------------------------------------|
| DESIGN JB | DRAWN BY RE | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED RE | APPROVED RE | DRAWING NO. D2013 |
| DATE 99.06.07 | TITLE MIRROR BRACKET | REV. C SHEET 3 OF 3 SCALE NTS |